Work Order Tuesday, July 09,			,	*103	9 <u>6</u> 0*							Pa	age 1
Revision ID:	04035-043	bly, Aft (350 Basket)		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	*N	S1	*
	//9/2013	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:				эсор	*N	Sy	*
	Process Plan	n:	Date: 13- 7-9  Date:	Tooling: SPC (Y/N):		ite:		]	Run	Start Stop	*N *N	R1 R2	*
Sequence ID/ Work Center ID		Operation Description	·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stam	
Draw Nbr	Revi	sion Nbr				-							
D4035	A												
100 *100* Large Fab		Weld per dwg A/R S.S.  Memo	rod Batch: Mid235	0.00				XIZ		13	3-07	10	MA
Large Fab		2- Drill hole 3- remove id	35-3 as per dwg D4035 es using DT9563 and chamfe dentification marks and debu hing in rib and grind weld fl	arr				-					
110		OC10- Inspect visual per	OSI004- ground welds	70.00									

\*110\*

Memo

Quality Control

0.00 PC 13.7.60

DQA:			Date:								•			***	A DT
						WORK ORDER NON-	-CC	ONFO	RMANCE / U						AEROSPACE
QA Closed:			Date:								Vork Or	der up	date only	$oldsymbol{\perp}$	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTI	MENT	/PROCESS		
	-					Rework	1		Skid-tube	Crosstube	7		Water Jet		Engineering
Part N	No.					Scrap		. [	Machining	Small Fab	<del>-</del>	Pro	d. Eng. Coor.	$\dashv$	Quality
	•					Use-as-is		Thern	noforming	Finishing	Re		re/Packaging		Other
NCR N	No.				_	Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Descr	iption of work order update		nitial	Act	tion	Siè	n &	<u> </u>	$\neg$	
Cause		Date	Step	Qty		or non-conformance	l	ief Eng		ription	1 -	ate	Verification	n	QC Inspector
Design														$\dashv$	
Doc/Data		•													·
Equip/Tooling															
Handling/Pre						• • •									
Material											'				
Operator							1								
Offset/Setup														- 1	
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Transport	Щ														
Unapproved							L.								· · · · · · · · · · · · · · · · · · ·
							FAL	ULT CAT	regory						
Landi		I				General		1		·			ı		
	$\vdash$	Bending	_		-	Bend	Н	1	Program	<u> </u> -	-		ensions	_	Pressure/Forced
	$\vdash$	Centre No	ot Concer	ntric		BOM/Route	H	Grain			_		tolerance	-	Set-up
	Cracks					Broken/Damage/Defect		Hardwa		<u> </u>		ncorrec		$\vdash$	Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs		1	ion Incomplete/Ui			ost/Mi	ssing	-	Weld
	Crushing					Contamination	-	1	tions Incomplete/U	Unclear	_	Vioved	!	'لب	Wrong Stock Pulled
	Crushing Heat Treat					Countersink	$\vdash$	1 -	ned/off center	-		ioned V			0.1
	Heat Treat Inspection Strip in Tube					Cut Too Short	_	Mislabe		L	Powe	r Loss/	Surge		Other
	Marks/Chatter					Drawing Drill Holos	_	Misread						—	
		1			-	Drill Holes	$\vdash$	Off-set							
		Turning S			-	Finish	-	4	Calibration				1		
	<u> </u>	Wave/Tw	ist in Tut	<i>J</i> e		Fit/Function		Out or S	Sequence						

Work Orde Tuesday, July 09				*10:	3960*			Page 2
Item ID: Revision ID: Item Name:		nbly, Aft (350 Basket)		Accept	*N900040	100* s	Setup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	7/9/2013 : 7/11/2013	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item ID: Customer:			
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Date:		Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 120 *170* QC Quality Control	D	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Accept Code Qty	U	Reject Insp. Number Stamp
130 *130* Packaging Packaging		Identify as per dwg & Sto	ock Location: <u>[WOO</u> 4	0.00		(12)	(	3-07-10 mA
140 <b>*14 *1 QC</b> Quality Control		QC21- Final Inspection -  Memo	Work Order Release	0.00			13/	7/11 H
							el (2	,0/110

DQA:	·	_ Date:						•				TOACE
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	ndate only	AEROSPACE
Work Orde		· · · · · ·			DISPOSITION			AGAIN		PARTMENT		
Part N NCR N	0				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstu  Machining Small F  noforming Finishi  Large Fab Compos	ab ng		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desci	ription of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved						FAL	ULT CAT	<b>FEGORY</b>				
Landin	g Gear				General							
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes	$\overline{}$	Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
<u> </u>		Sequence wist in Tul			Finish Fit/Function	-	1	Calibration Sequence	_Q^ (		· · · · · · · · · · · · · · · · · · ·	

Work Order ID:

103960

Parent Item:

D4035-043

Parent Item Name:

Lid Rib Assembly, Aft (350 Basket)

**Start Date:** 7/9/2013

Required Date: 7/11/2013

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

**Comments:** 

IPP revA: new issue DD 09.11.25 verified by:EC

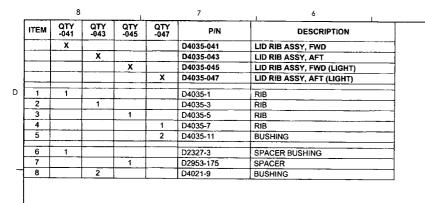
IPP Rev:B as per dwg revA 10.03.15

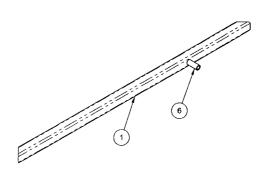
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-9 Bushing		Manufactured	No		· .	100	Each	277.0000	2	24			
				Location		Loc Oty	Lo	oc Code			1~	- 10	
B 10354	187 X24			WA		36					- 13 -	-07-10	$m_A$
ターリング・	$\underline{\underline{\upsilon}}$ , $\lambda \omega$ .			103	3746	36							·
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				991	143	2		_					
				WA004		235				<del></del>			
					)402	55				<del> </del>			*
					917	40							
					2664	80							
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				703	333	4				ж			
				724	182	4			-				
				829	77	1			-				
				847	117	3							
				880	)77	23							
				883	377	7				<del></del>		ş.	
				920	)20	12						,.	
		*		988	377	4							
<b>M304TS0.750W.049</b> 304 SQ Tube .75x.75x.049	PW	Purchased	No			100	f	965.6694	1.75	22.105263		*	
				<b>Location</b>		Loc Qty	Lo	c Code				ĺ	
				MAT017		20 6222084			J	-			

MAT017 39.6232084 124492 39.6232084 WA006 926.0461491 28.9999555 280.306667 148.546527 M126039 468.193

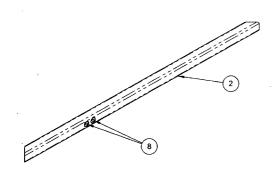
13-07-10 MAL

DQA:			Date:										T	
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / L	JPDATE				
QA Closed:			Date:				_				Wo	rk Order up	date only	
Work Orde	er:					DISPOSITION	*			AGAINST	DEP	ARTMENT	PROCESS	
Part N	lo.					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	10					Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desci	ription of work order update	Ī	nitial	Ad	tion	T	Sign &	· · · · · · · · · · · · · · · · · · ·	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup														
Process Supplier Training Transport Unapproved														
		· · · · · · · · · · · · · · · · · · ·				<del></del>	FAL	JLT CAT	regory					
Landir		Bending Centre No Cracks				General Bend BOM/Route Broken/Damage/Defect Burrs		Grain Hardwa	rogram re ion Incomplete/U	Inqualified		Outside Dimo Over/Under Part Incorrec Part Lost/Mi	tolerance t	Pressure/Forced Set-up Temperature/Cure Weld
	Crimp/Kink/Ripple/Wave Cuffs Crushing					Contamination Countersink		Instruct	ions Incomplete, aned/off center	/Unclear		Part Moved Positioned W		Wrong Stock Pulled
	Heat Treat					Cut Too Short	-	Mislabe			Н	Power Loss/S		Other
		Inspection	n Strip in	Tube		Drawing	$\vdash$	Misread				·		
:		Marks/Ch	atter			Drill Holes		Off-set			_			
		Turning Se				Finish		Out of (	Calibration		_		į	
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence					

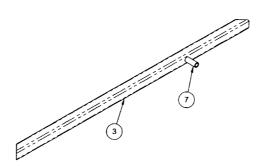




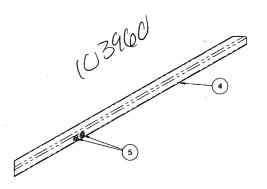
**D4035-041 BASKET LID RIB ASSY, FWD** 



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

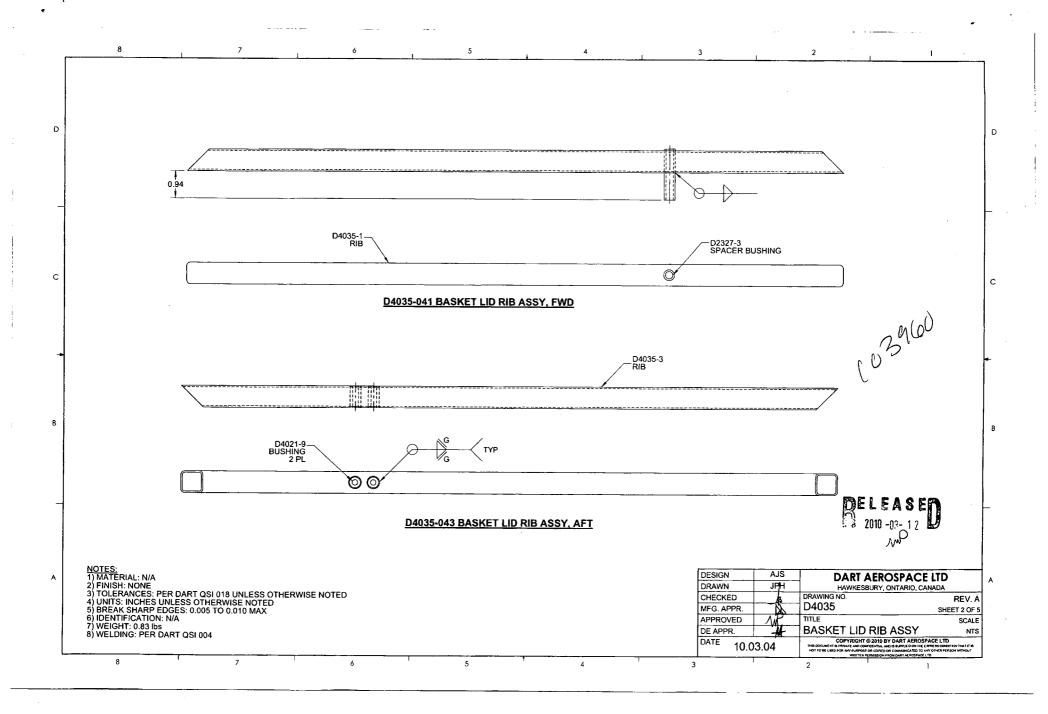


**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)** 

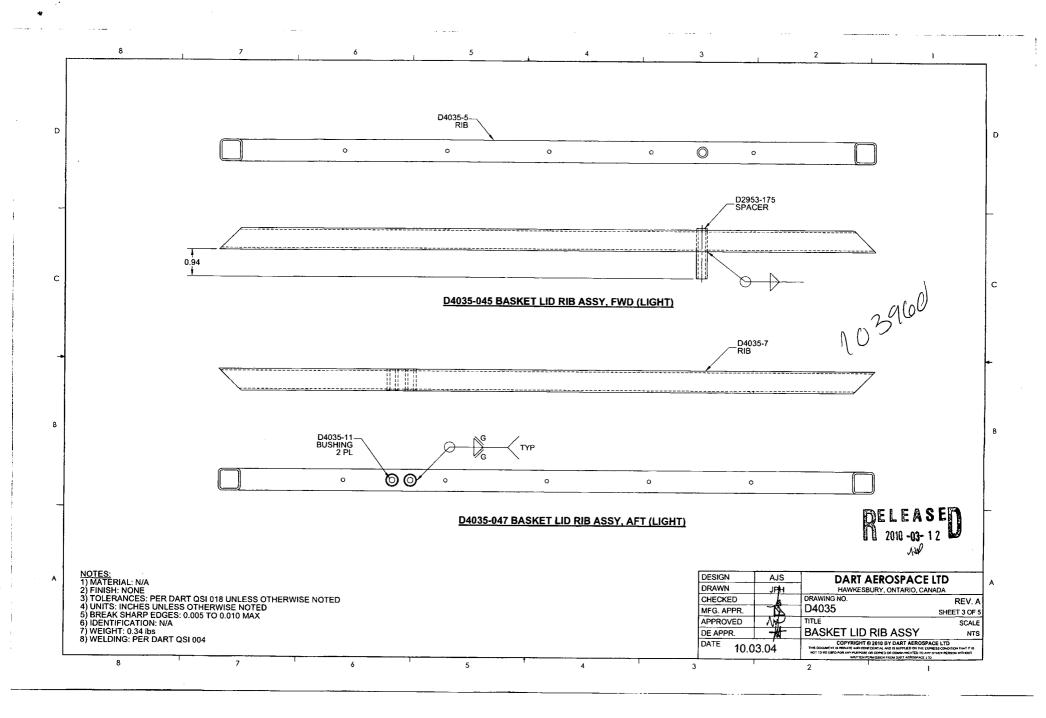


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APPRO	VED	W	TITLE		SCALE
DE APP	PR.	-#	☐ BASKET LID RIB A	SSY	NTS
DATE	10.0	3.04	COPYRIGHT © 2010 BY DA  THIS COCUMENT IS PRIVATE AND CONFIDENTIAL AND IS ST  NOT TO BE USED FOR ANY PURPOSE OF COPIED OR COM- WOTTEN PERMISSION FROM OF	PPLEO ON THE EXPRI	ES CONDITION THAT IT IS

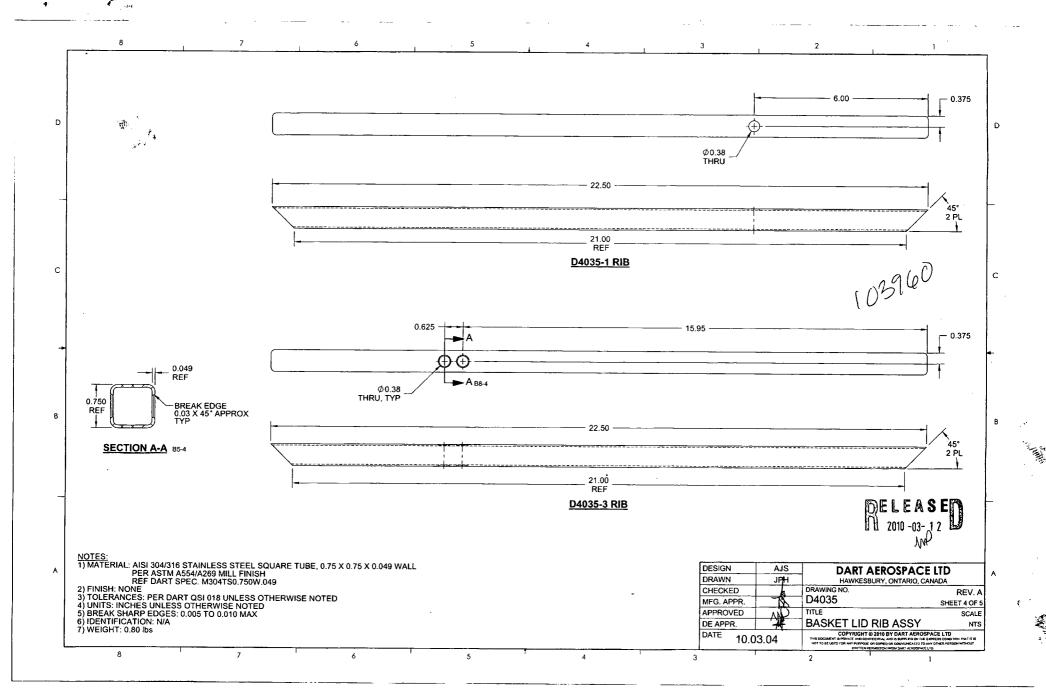
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						WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE			A E R O S P A C E
QA Closed:			Date:							V	Vork Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	-					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	۱o.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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NCR N	Ю.					Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	!	ief Eng		ription	Date	Verification	QC Inspector
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		Bending			<u> </u>	Bend		Folio/P	rogram	Ĺ	Outside Dim	ensions	Pressure/Forced
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	$\vdash$	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Temperature/Cure
	Crimp/Kink/Ripple/Wave				ļ	Burrs	L	Inspect	ion Incomplete/U	nqualified	Part Lost/M	issing	Weld
	Cuffs					Contamination	_	1	ions Incomplete/	Unclear	Part Moved	Į	Wrong Stock Pulled
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	Inspection Strip in Tube					Drawing		Misread					1
	Marks/Chatter					Drill Holes		Off-set					
	Turning Sequence					Finish	L_	1	Calibration				
	L	Wave/Tw	ist in Tub	oe		Fit/Function	L	Out of S	Sequence			<u>.                                    </u>	



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Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	-					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor	-	Quality
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NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	'n	QC Inspector
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	Heat Treat Inspection Strip in Tube					Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge	L	Other
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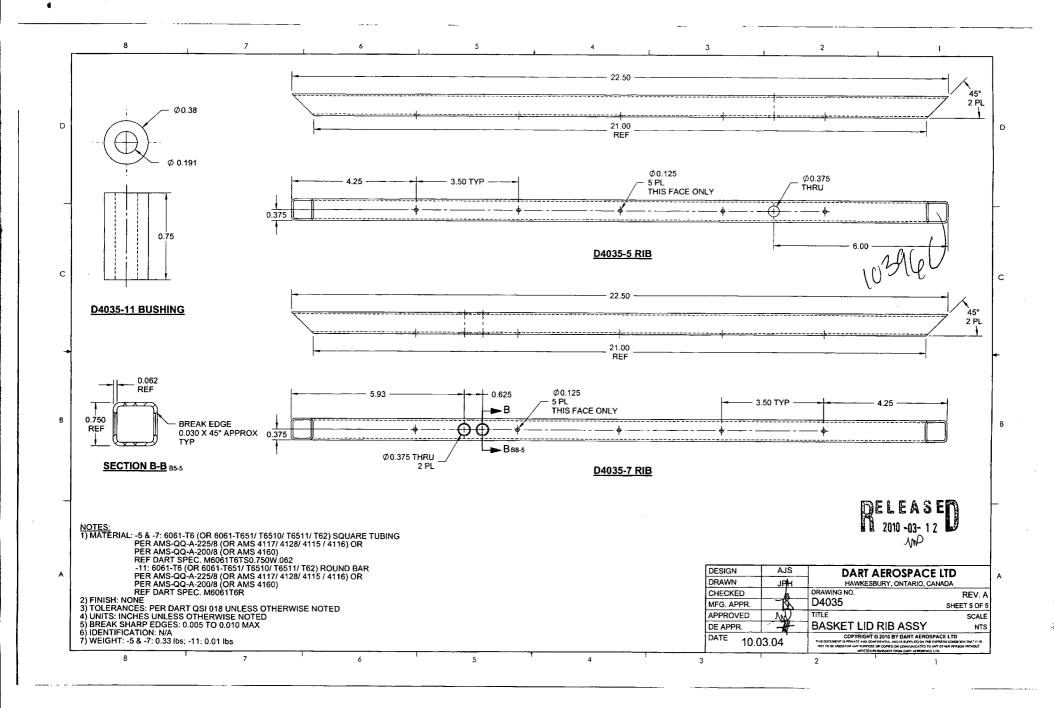


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					WORK ORDER NON-	-CC	ONFO	RMANCE / UP	PDATE				AEROSPACE
QA Closed:		Date:								W	ork Order up	odate only	
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo	·		<u>.</u>	Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	${}$	Rec/Sto	re/Packaging Supplier	Other
Root				Desci	ription of work order update	ı	nitial	Acti	on		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	QC Inspector
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Inapproved													
						FA	ULT CA	TEGORY					
Landir	ng Gear				General		_						
	Bending				Bend		Folio/F	Program			Outside Dim	ensions	Pressure/Forced
	Centre No	ot Conce	ntric		BOM/Route		Grain			L	Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	ct	Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs		inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/U	nclear		Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	gned/off center			Positioned V	Vrong _	
	Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other
	Inspectio	n Strip in	Tube		Drawing		Misrea	d				<u> </u>	
[	Marks/Ch	natter			Drill Holes		Off-set						
	Turning S	equence	•		Finish		Out of	Calibration					
,	Wave/Tw	ist in Tul	be		Fit/Function		Out of	Sequence					



DQA:			Date:											•	NA PT
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QA Closed:			Date:				-				Work	Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST [	DEPA	RTMENT	PROCESS		
	-					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	_	Proc	d. Eng. Coor.		Quality
	•		<u> </u>	:		Use-as-is			noforming	Finishing			e/Packaging		Other
NCR N	۱o.					Suspected Unapproved			Large Fab	Composite		•	Supplier		
Root		-			Desc	ription of work order update		nitial	Δ	ction		Sign &			
Cause		Date	Step	Qty	Desci	or non-conformance	ĺ	ief Eng	i	cription		Date	Verificatio	n	QC Inspector
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		Centre No	ot Concer	ntric		BOM/Route	L	Grain			o	ver/Under	tolerance		Set-up
	-	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		1	—	art Incorrec		<u>_</u>	Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs	L	1 '	ion Incomplete/l	· · · · · · · · · · · · · · · · · · ·	_	art Lost/Mi	ssing		Weld
	Cuffs					Contamination	_	4	tions Incomplete,	<del> -</del>	_	art Moved		Ļ.	Wrong Stock Pulled
	Crushing					Countersink	_	1 `	gned/off center	·	_	ositioned <b>V</b>	-		1
	Heat Treat Inspection Strip in Tube					Cut Too Short	$\vdash$	Mislabe		L	Po	ower Loss/	Surge	Ļ	Other
	<u> </u>	1	•	Tube		Drawing	_	Misrea			_			-	
	Marks/Chatter					Drill Holes	$\vdash$	Off-set						1	
	<u> </u>	Turning S	-		_	Finish	<u> </u>	4 .	Calibration		_				
4		Wave/Tw	ist in Tub	Эе		Fit/Function		Out of	Sequence						

H:/FQRMS/Quality Assurance\approved QA/NCRWO RevH



DQA:			Date:			•	DART						
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDAT		ork Order up	date only	AEROSPACE
Work Orde	er:					DISPOSITION			A	GAINST DE	PARTMENT	PROCESS	
Part N	_				<u> </u>	Rework Scrap Use-as-is Suspected Unapproved			Machining Sm noforming Fi	osstube nall Fab nishing nposite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
				<del></del>			FA	ULT CAT	regory				
Landi	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube					General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unqualif ions Incomplete/Unclea ined/off center eled	r	Outside Dime Over/Under Part Incorrec Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw	ist in Tub	e	1	Fit/Function		Out of 9	Sequence				